

Date: Tuesday, 9/25/2007 10:09:37 AM
 User: Kim Johnson

Process Sheet

Split

41

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 34836
 Estimate Number : 10824
 P.O. Number : *N/A*
 This Issue : 9/25/2007 S.O. No. : *N/A*
 Prsht Rev. : *NC*
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 33696
 Part Number : D412630032
 Drawing Number : IIN *UREV* P19 07.09.25 *BC*
 Project Number : *N/A*
 Drawing Revision : *K*
 Material : *N/A*
 Due Date : 10/9/2007 Qty: *3* Um: Each
 Written By : *JA 07.09.25*
 Checked & Approved By : *JA 07.09.25*
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0 D3463042 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3463-042 Step weldment *333705*

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-043 Strut ass'y *B33699*

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-041 Strut ass'y *B35189 x2*
B29671 x1

Tuesday, 9/25/2007 10:09:37 AM

Kim Johnston

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D34439	PIN
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3443-9	Pin

Batch

B30228

7.0	AN4CH3	SS Bolt
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
2	AN4CH3	BOLT
A/R	MS20995c41e	Lockwire

Batch

M103248
M101537

8.0	AN4C14	BOLT
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN4C14	BOLT

Batch

M103248

9.0	D34547	Bushing
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3454-7	Bushing

Batch

B33701

10.0	AN3104	NUT
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	AN310-4	Nut

Batch

M105057

CP 5/10/15

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

MS24665-227

COTTER PIN

M102073



12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-1

Spacer

B28171



13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3465-1

Washer

B33706



14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-7

Nut

M103286



15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

MS24665-302

COTTER PIN

M116941



8/507/10/154

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

7-11-16 (3)

E. A. 11/16

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3454-1

Bushing

B33730-

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3454-3

Bushing

B35171

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3454-5

Bushing

B33700-3A-5X

B24842 3X

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

6

D3455-1

Spacer

B28171-

E. A. 10/15/07

Tuesday, 9/25/2007 10:09:37 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-3	Spacer	B28 172

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3462-042	Bracket ass'y	B 34843

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	M10557 3x

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-5	Nut	M10524 2x M10524 6x

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M105426

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44C12	eyebolt	M106170 3x

M106170 3x

~~M105761 1x~~

Tuesday, 9/25/2007 10:09:37 AM
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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 AN44-C12 Eyebolt

28.0 AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN4C15 BOLT

Batch

M19213 ~~34~~ M103228 1x *2*

29.0 AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN5C11 BOLT

Batch

M103248

30.0 AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN5C15 BOLT

Batch

M105160

31.0 AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total: 28.0000 EACH(s)

Pick:

Qty Part Number Description Batch
7 AN960C10 Washer

Batch

M101064

32.0 AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960C516 Washer

Batch

M17657

Tuesday, 9/25/2007 10:09:37 AM

Kim Johnston

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Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description:

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

3

MS21043-3

Nut

M105728

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-227

COTTER PIN

M102073 5X

M106073 3X

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-229

COTTER PIN

M19096

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

M105792

7/10/10 (4)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

A 7/11/19 (3)

1
Tuesday, 9/25/2007 10:09:37 AM
sr: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 34836

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-11-19

07/11/19

FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

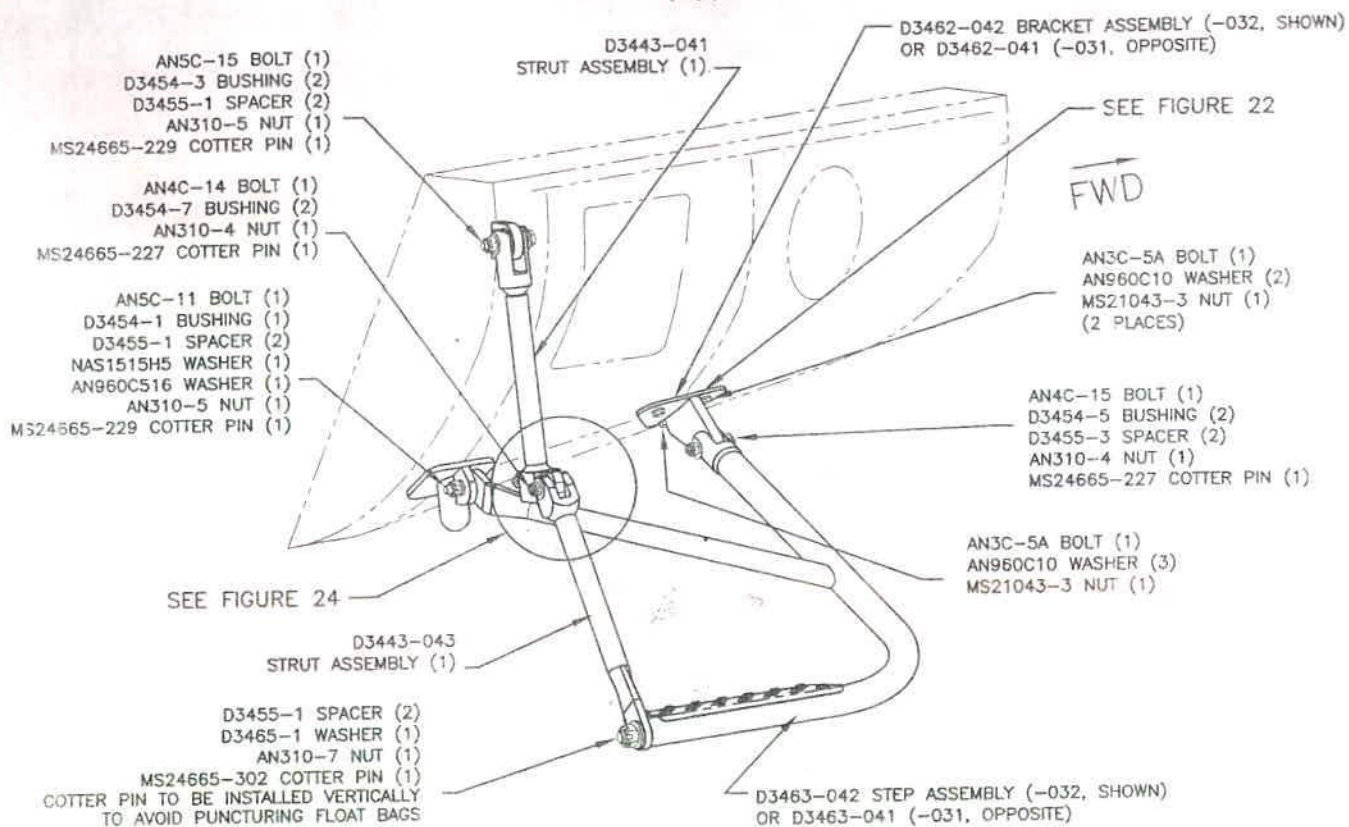
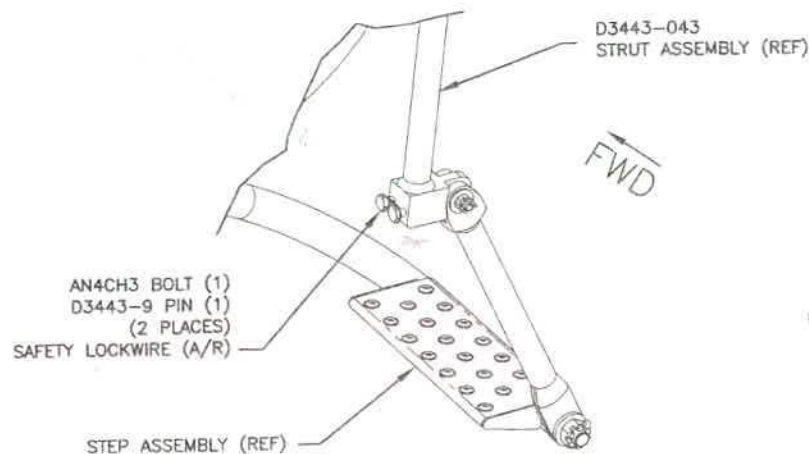


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34836

Date: Tuesday, 9/25/2007 10:09:37 AM
 User: Kim Johnston

Process Sheet

41

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 34836		
Estimate Number	: 10824		
P.O. Number	:	Part Number	: D412630032
This Issue	: 9/25/2007 S.O. No. :	Drawing Number	: IIN W/REV P19 07.09.25 DC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: K
Previous Run	: 33696	Material	:
Written By	:	Due Date	: 10/9/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.09.25</u>		
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC EST. REV. B 05.12.19 updated pick list EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

07.09.26 HA

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0	D3463042	Step Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	

REFERENCE ONLY

5.0	D3443041	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	